

Work Order ID 134458

134458

Page 1

Wednesday, July 08, 2015 3:15:26 PM

Item ID: D3589-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Assembly
 Start Date: 7/07/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUL 10 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	C

100 0.00 ***100*** 2 15-10-07 JBL

Large Fab Memo 0.04
 Large Fab 1- Form D3589-11, assemble and weld D3589-9 to D3589-11 as per dwg D3589
 2- grind weld flush as per dwg D3589
 3- slide (4) D3589-3 Arm Guides on D3589-1 Arm and weld D3589-13 lugs on both ends as per dwg D3589
 *** ensure that the 4 ARM GUIDES are on the ARM before welding both LUGS***
 4- using DT9033 jig install parts on door and weld as per dwg D3589 QSI004
 ensure parts fit correctly on jig
 A/R Stainless Steel Rod Batch: 123823

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
 QC Memo 0.00
 Quality Control

② 15-10-07 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130									
Small Fab	Memo	0.01							
Small Fab	1- Assemble as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
OCT 08 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>57231</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

2 *SM*
15/10/8

MCS **OCT 03 2015**

MCS **OCT 03 2015**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Wednesday, July 08, 2015 3:15:25 PM

Page 1

Work Order ID: 134458

134458

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue 08-06-05 DD verified by:ec IPP RevB: revise process as per coss DD 10.01.18 verified by:EC IPP REV:C 12.07.23 AS PER REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-1		Manufactured	No			100	Each	4.0000	1	2			
										**			
D3589-1													
Arm													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	4						
						131118	2						
						133187	2						
D3589-11		Manufactured	No			100	Each	4.0000	1	2			
										**			
D3589-11													
Fwd Guide Plate													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	4						
						122856	4						
D3589-13		Manufactured	No			100	Each	8.0000	2	4			
										**			
D3589-13													
Lug													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	8						
						113171	8						
D3589-15		Manufactured	No			130	Each	11.0000	2	4			
										**			
D3589-15													
Link													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						WA002	11						
						123046	11						

15-10-06
JBL

15-10-06
JBL

15-10-06
JBL

FF OCT 08 2015

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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Wednesday, July 08, 2015 3:15:25 PM

Page 2

Work Order ID: 134458

134458

Parent Item: D3589-041

D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

D3589-23 Manufactured No

100 Each 21.0000 2 4

D3589-23

Arm Guide

15-10-06

JBL

Location Loc Qty Loc Code

WA002 21

114880 21

D3589-3 Manufactured No

130 Each 9.0000 2 4

D3589-3

Arm Guide

15-10-06

JBL

Location Loc Qty Loc Code

WA002 9

110528 3

130891 2

133405 4

D3589-7 Manufactured No

100 Each 12.0000 1 2

D3589-7

Aft Guide Plate

15-10-06

JBL

Location Loc Qty Loc Code

WA002 12

125158 4

126313 8

D3589-9 Manufactured No

100 Each 3.0000 1 2

D3589-9

Fwd Guide Plate

15-10-06

JBL

Location Loc Qty Loc Code

WA002 3

122957 1

133123 2

Wednesday, July 08, 2015 3:15:25 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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D3589-041

Parent Item Name: Latch Assembly

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

MS20392-1C7

Purchased

No

130

Each

40.0000

2

4

MS20392-1C7

Pin

6
9-89

Location

Loc Qty

Loc Code

ST314

40

m128976

40

MS24665-1010

Purchased

No

130

Each

248.0000

2

4

MS24665-1010

COTTER PIN

DAS
6
9-89

Location

Loc Qty

Loc Code

ST293

248

108335

200

114405

48

NAS1149DN432J

Purchased

No

130

Each

203.0000

4

8

NAS1149DN432.J

WASHER

7636

DAS
8
9-89

Location

Loc Qty

Loc Code

CA

203

m129682

203

Wednesday, July 08, 2015 3:15:25 PM

Shop Packet Print

Page 3

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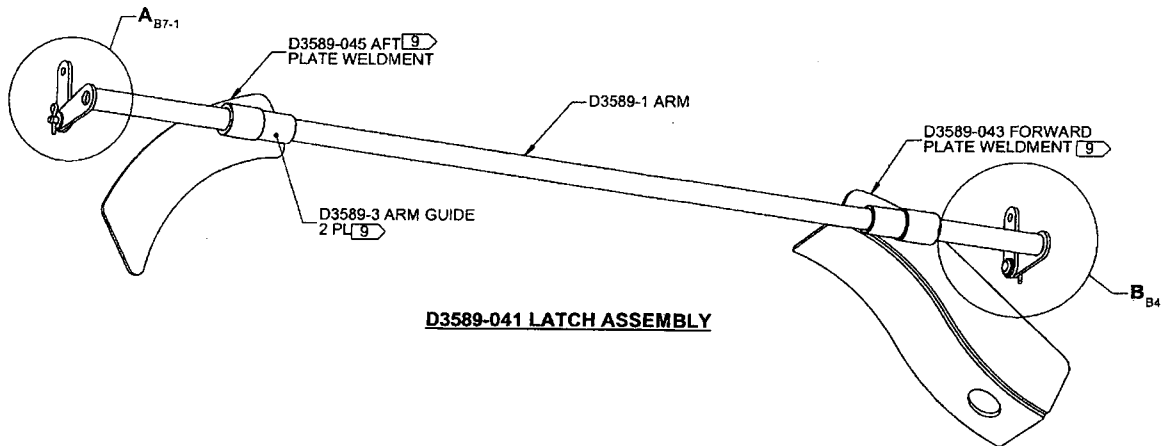


WORK ORDER NON-CONFORMANCE / UPDATE

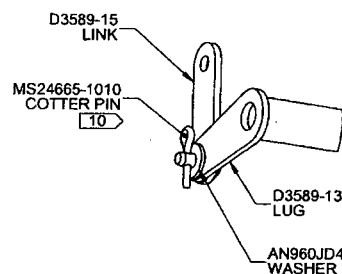
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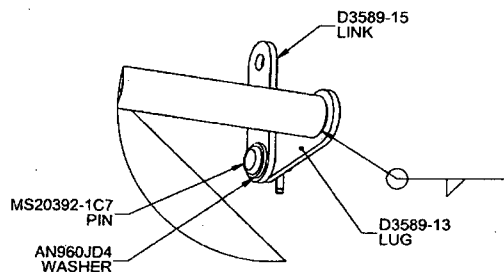
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Misidentified ☐	Past Due ☐								



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
D8-1
SCALE 2X
2 PL



DETAIL B: WELDING AND LINK ASSEMBLY DETAIL
C3-1
SCALE 2X
2 PL

ITEM	QTY.	P/N	DESCRIPTION
	X	D3589-041	LATCH ASSEMBLY
1	1	D3589-043	FORWARD PLATE WELDMENT
2	1	D3589-045	AFT PLATE WELDMENT
3	1	D3589-1	ARM
4	2	D3589-3	ARM GUIDE
5	2	D3589-13	LUG
6	2	D3589-15	LINK
7	4	AN960JD4	WASHER
8	2	MS20392-1C7	PIN
9	2	MS24665-1010	COTTER PIN

C	REVISED D3589-5: 2.75 WAS 3.00 (ZN B6-4); ADDED D3589-21 (ZN B3-4); AFFECTS D3589-047 (ZN A7-3) AND D3589-049 (ZN A3-3); REVISED D3589-15: Ø 0.140 WAS Ø 0.129 (ZN B4-7); 0.900 WAS 1.150 (ZN C4-7); ADDED D3589-23 (ZN C3-4); AFFECTS D3589-043-045 (ZN D7-2 AND D2-2); REASON: PAR12-117.	MB	12.07.04
B	0.90 AND 0.83 REF WERE 1.87 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 28" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3); REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION	MB	08.06.25
A	NEW ISSUE	MB	08.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.07.04		

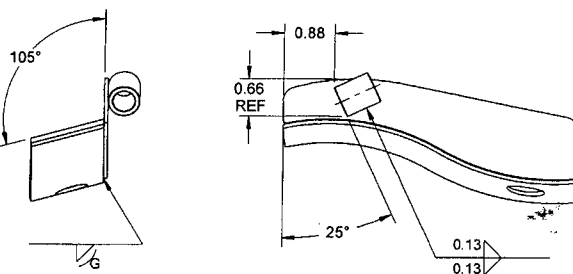
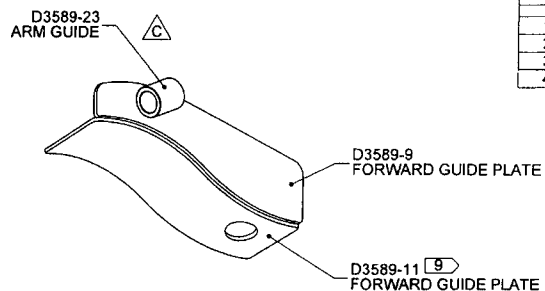
- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
 - 7) WEIGHT: 0.75 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

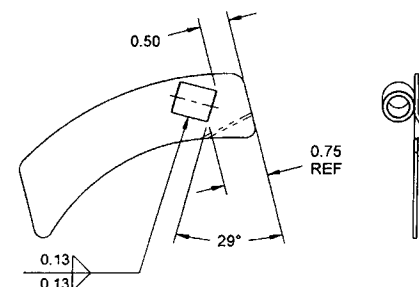
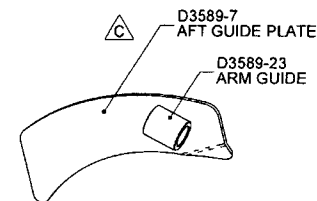
DRAWING NO. **D3589** REV. C
SHEET 1 OF 8
TITLE **LATCH ASSEMBLY** SCALE NTS

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ITEM	QTY -043	QTY -045	P/N	DESCRIPTION
	X		D3589-043	FORWARD PLATE WELDMENT
		X	D3589-045	AFT PLATE WELDMENT
1		1	D3589-7	AFT GUIDE PLATE
2	1		D3589-9	FORWARD GUIDE PLATE
3	1		D3589-11	FORWARD GUIDE PLATE
4	1	1	D3589-23	ARM GUIDE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

RELEASED
2012-07-16

D3589-043/-045 NOTES:

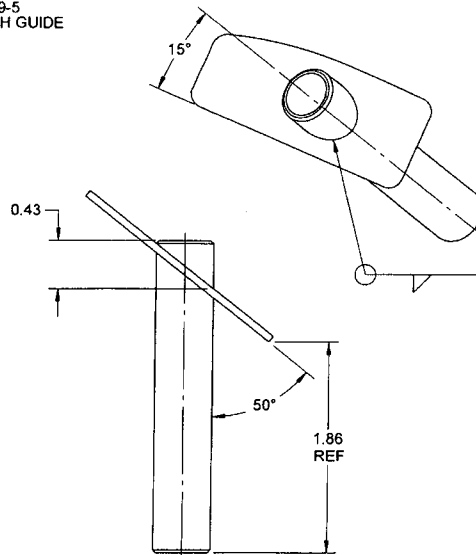
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-043 = 0.23 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3589	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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ITEM	QTY -047	QTY -049	P/N	DESCRIPTION
	X		D3589-047	FORWARD GUIDE
		X	D3589-049	AFT GUIDE
1	1		D3589-5	LATCH GUIDE
2	1		D3589-17	FORWARD GUIDE PLATE
3		1	D3589-19	AFT GUIDE PLATE
4		1	D3589-21	LATCH GUIDE

D3589-17
FORWARD GUIDE PLATE

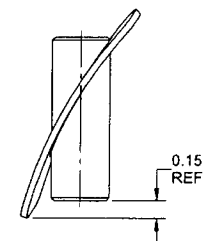
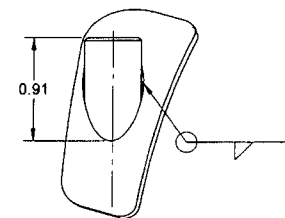
D3589-5
LATCH GUIDE



D3589-047 FORWARD GUIDE

D3589-21
LATCH GUIDE

D3589-19
AFT GUIDE PLATE



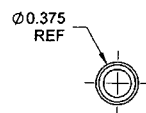
D3589-049 AFT GUIDE

D3589-047/-049 NOTES:

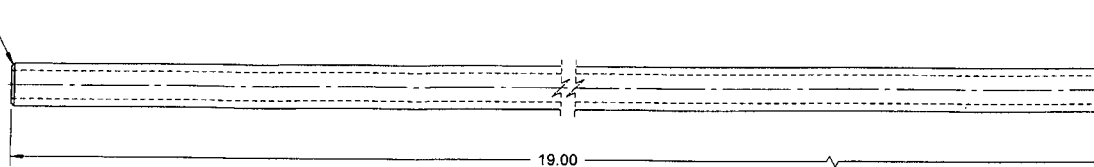
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
 - D3589-047 = 0.08 lbs
 - D3589-049 = 0.05 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO. D3589	SHEET 3 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		LATCH ASSEMBLY	NTS
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DATE	12.07.04		

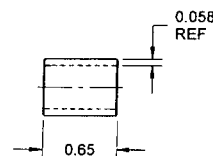
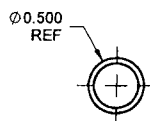
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2012-07-16
MP



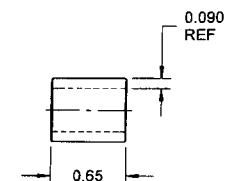
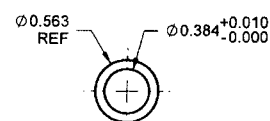
0.03 X 45°
CHAMFER
2 PL



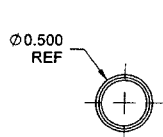
D3589-1 ARM



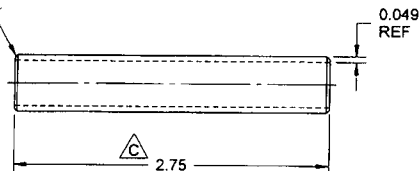
D3589-3 ARM GUIDE



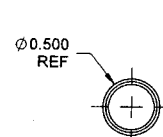
D3589-23 ARM GUIDE



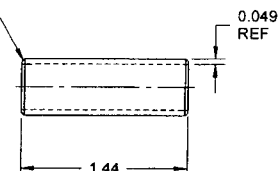
0.03 X 45°
CHAMFER
2 PL



D3589-5 LATCH GUIDE



0.03 X 45°
CHAMFER
2 PL



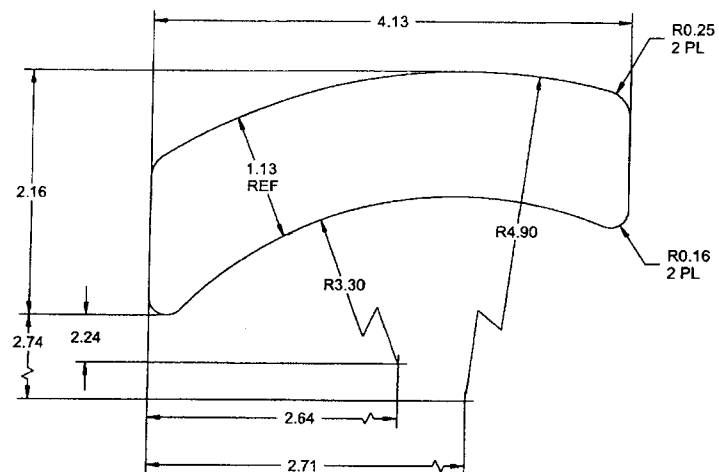
D3589-21 LATCH GUIDE

D3589-1/-3/-5/-21/-23 NOTES:

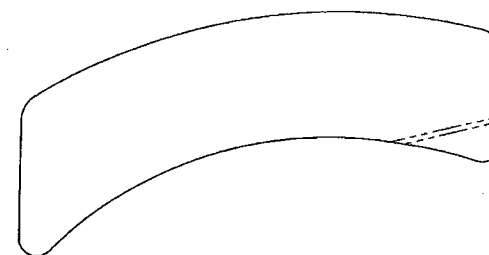
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 - D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 - D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 - D3589-5/-21: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
 - D3589-23: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276 (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT:
 - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs
 - D3589-21 = 0.03 lbs
 - D3589-23 = 0.02 lbs

RELEASE
2012-07-16

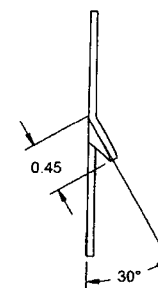
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3589	SHEET 4 OF 8
APPROVED			TITLE	SCALE
DE APPR.			LATCH ASSEMBLY	NTS
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**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**

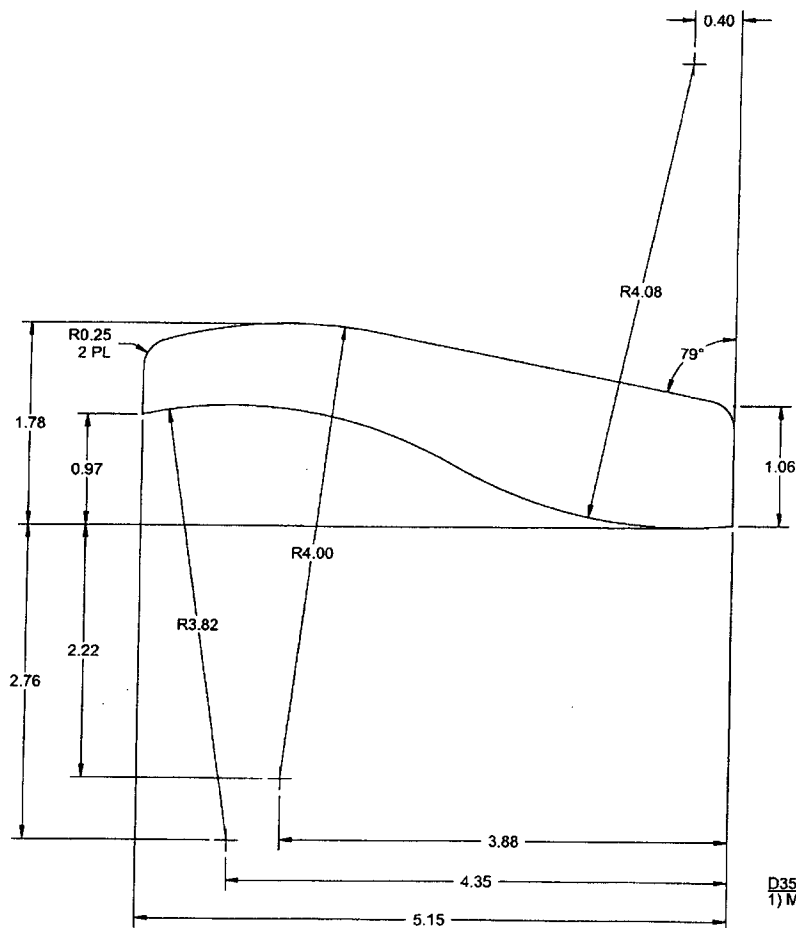


D3589-7F NOTES:

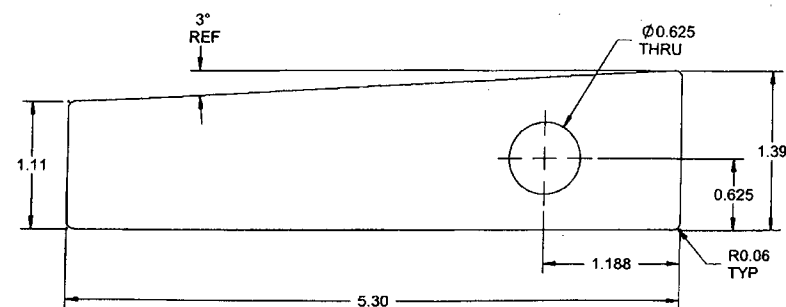
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

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2012-07-16

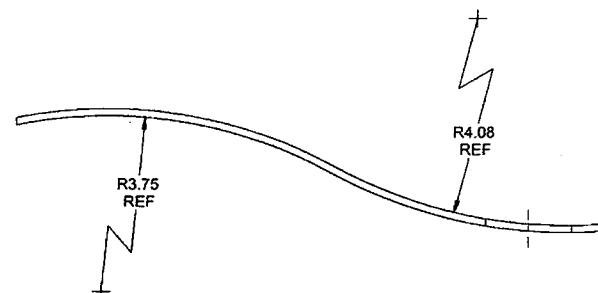
DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D3589	REV. C
MFG. APPR.		TITLE	SHEET 5 OF 8
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DE APPR.			NTS
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D3589-9 FORWARD GUIDE PLATE



**D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN**



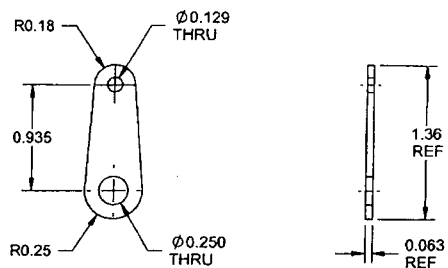
**D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)**

D3589-9/-11/-11F NOTES:

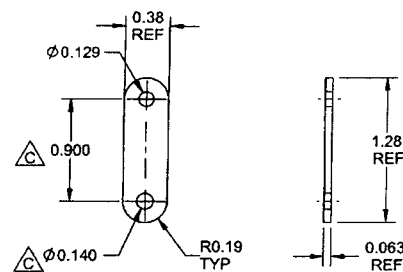
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK),
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

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2012-07-16

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LATCH ASSEMBLY	NTS
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D3589-13 LUG



D3589-15 LINK

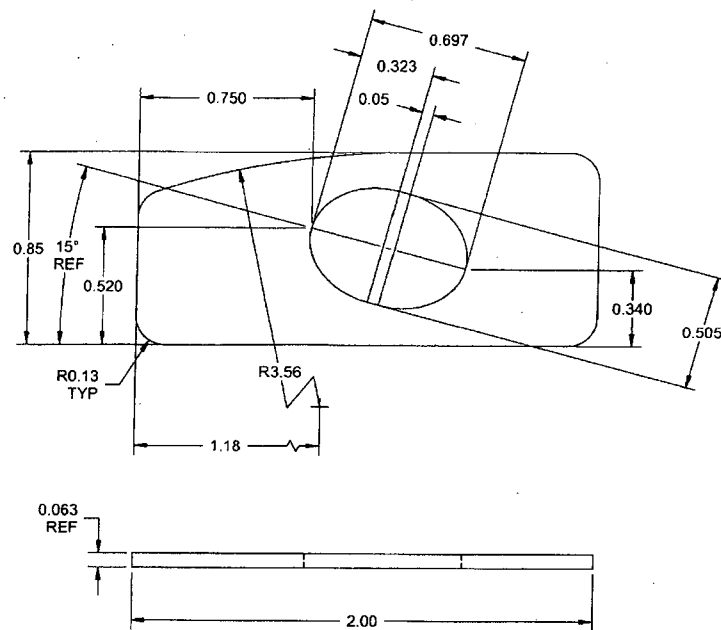
RELEASED
2012-07-16
MD

D3589-13/-15 NOTES:

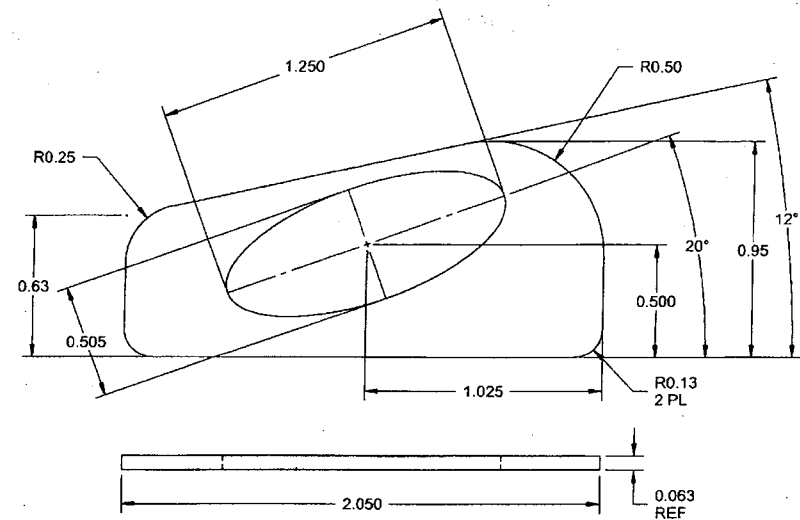
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3589 REV. C
MFG. APPR.		SHEET 7 OF 8
APPROVED		TITLE LATCH ASSEMBLY SCALE NTS
DE APPR.		
DATE	12.07.04	

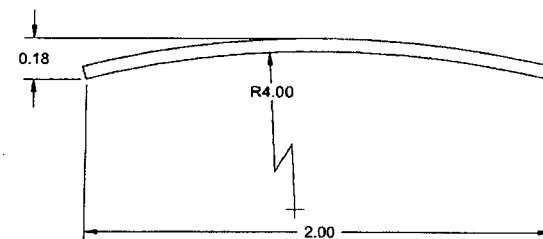
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D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

RELEASED
R 2012-07-16

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3589	REV. C
MFG. APPR.		TITLE LATCH ASSEMBLY	SHEET 8 OF 8
APPROVED		SCALE	NTS
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